

SHIP 14 MAY

Work Order ID 58437

May 6, 2010 2:52:29 PM

Page 1

Item ID: D3371-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Pedal Lock Cover

Start Date: 06/05/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank: 2.00" x 2.25" x 7.370" long

0.00

0.00

10/05/12

4 0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3371-3 as per Folio FA486 and Dwg D3371
 2-Deburr
 3-Finish 8-32 thread by hand
 Identify as D3371-3

0.00

0.00

10/05/12

10/05/13

3 1

120



QC

Quality Control

QC2- Inspect parts off machine-FAI/FAIB

Memo

0.00

0.00

10/05/12

10/05/13

3 1

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-3 PAR #: _____ Fault Category: machining NCR: Yes No DQA: _____ Date: 1005.12
 Resolution: Scrap Disposition: scrap QA: N/C Closed: ✓ Date: 10/05/17

NCR: <u>58437</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>1005.12</u>	<u>110</u>	<u>1 cover scrap, tool holder hit the top of the part. tool length was not clearly identified on the Polio Rev. AA. R.C. Polio</u>	<u>[Signature]</u>	<u>Scrap is destroyed & no replace. Complete tool sheet to revise the Polio</u>	<u>[Signature]</u> <u>10/05/12</u>	<u>[Signature]</u> <u>10/05/13</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>1005.12</u>

NOTE: Date & initial all entries

Work Order ID 58437

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Page 2

Item ID: D3371-3

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Setup Start



Revision ID:

Item Name: Pedal Lock Cover

Stop



Start Date: 06/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Ans/10-05-12

3

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

(3) BK 10-5-13.

145

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

****cover inside holes prior painting****

Start Time: *12:00pm*
Oven Temperature: *320°F*
Finish Time: *12:20pm*

=) Jul 10/05/13

3

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58437

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Page 3

Item ID: D3371-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Cover

Start Date: 06/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				③	BR	10-5-13.	
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>493</u> Memo	0.00 0.00							<u>Per 10/5/13</u> ③
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/05/17</u> <u>mk</u> 10-5-14

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 6, 2010 2:52:34 PM

Page 1

Work Order ID: 58437



Parent Item: D3371-3



Parent Item Name: Pedal Lock Cover

Start Date: 06/05/2010

Required Date: 13/05/2010

Comments: IPP A□05.01.18□New issue□KJ/JLM□

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	9.5000	0.625			



6061-T6 Bar 2.00 x 2.25

Location

Loc Qty

Loc Code

MAT09

9.5

16427

9.5

2,4567 DIP 10/05/12
No more material left.

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58437
Description: Pedal Lock Cover		Part Number:	D3371-3
Inspection Dwg: D3371	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.450	+/-0.005	1.450	✓			
7°	+/-0.5°	7°	✓			
0.104	+/-0.010	0.100	✓			
0.305	+/-0.010	0.303	✓			
1.650	+/-0.010	1.649	✓			
1.30	+/-0.030	1.30	✓			
Ø1.000	+/-0.010	0.999	✓			
45°	+/-0.5°	45°	✓			
Ø1.300	+/-0.010	1.300	✓			
0.500	+/-0.010	0.510	✓			
60°	+/-0.5°	60°	✓			
2.25	+/-0.030	2.24	✓			
1.650	+/-0.010	1.653	✓			
3.950	+/-0.010	3.950	✓			
1.330	+/-0.005	1.135	✓			
7.19	+/-0.030	7.180	✓			
4.500	+/-0.010	4.509	✓			
0.635	+0.010/-0.000	0.636	✓			
1.125	+/-0.010	1.120	✓			
0.750	+/-0.010	0.756	✓			
Ø0.750	+0.010/-0.000	0.75	✓			
3.625	+/-0.010	3.62	✓			
Ø1.200	+/-0.010	1.197	✓			
0.750 deep	+/-0.010	0.750	✓			
0.500	+/-0.010	0.494	✓			
2.00	+/-0.030	1.980	✓			
1.000	+/-0.010	0.995	✓			
0.375	+/-0.010	0.370	✓			
Ø0.185	+0.005/-0.000	0.188	✓			
0.400 deep	+/-0.010	0.410	✓			

Measured by:	DTA	Audited by:	DTA	Prototype Approval:	N/A
Date:	10/05/12	Date:	10/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

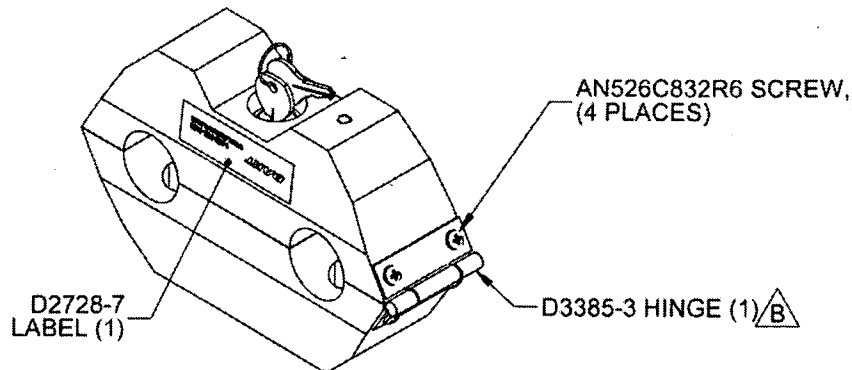
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

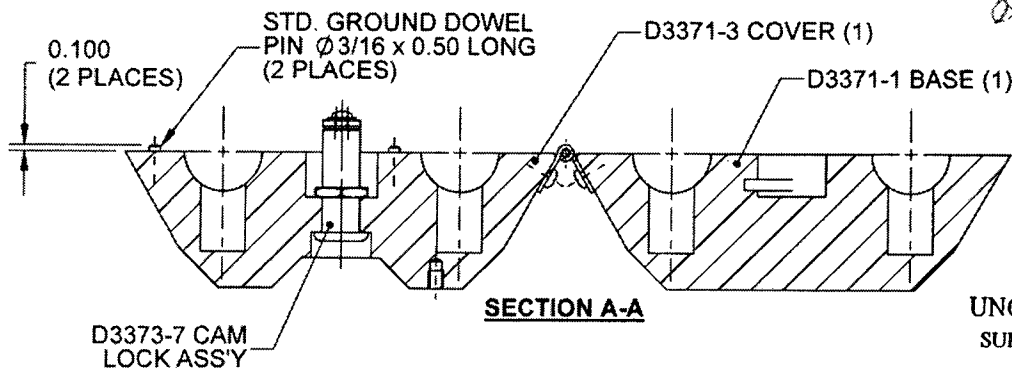


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



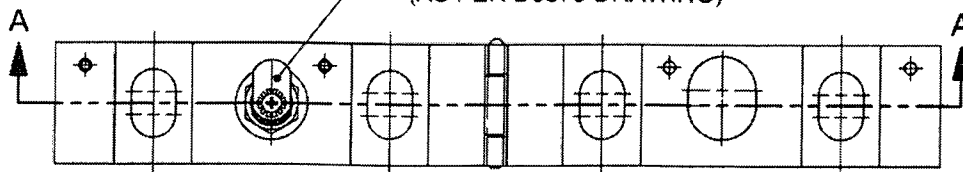
PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58432

D3371-5 CAM (1),
AND SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1)
(AS PER D3373 DRAWING)



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

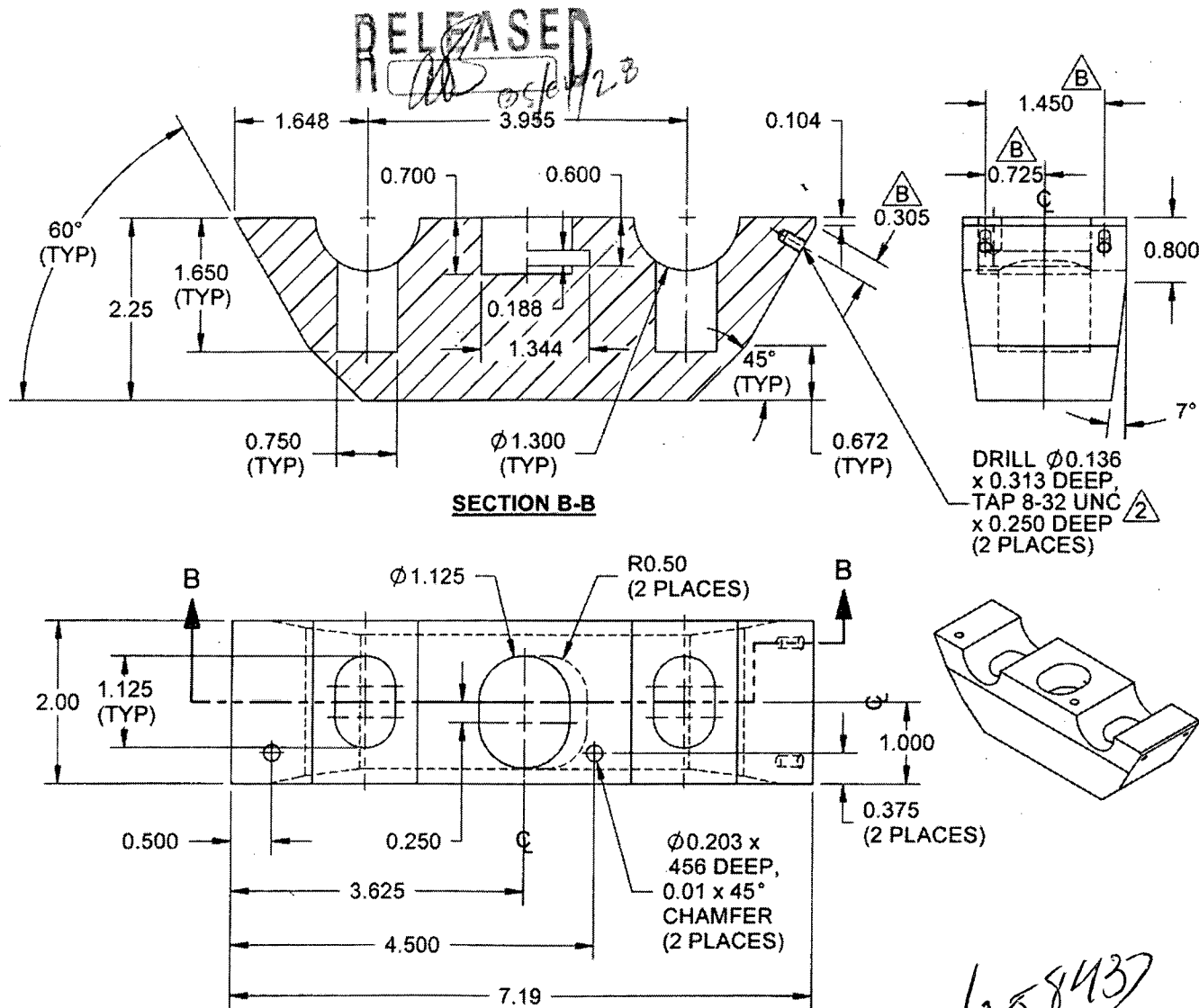
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-1 BASE

NOTES:

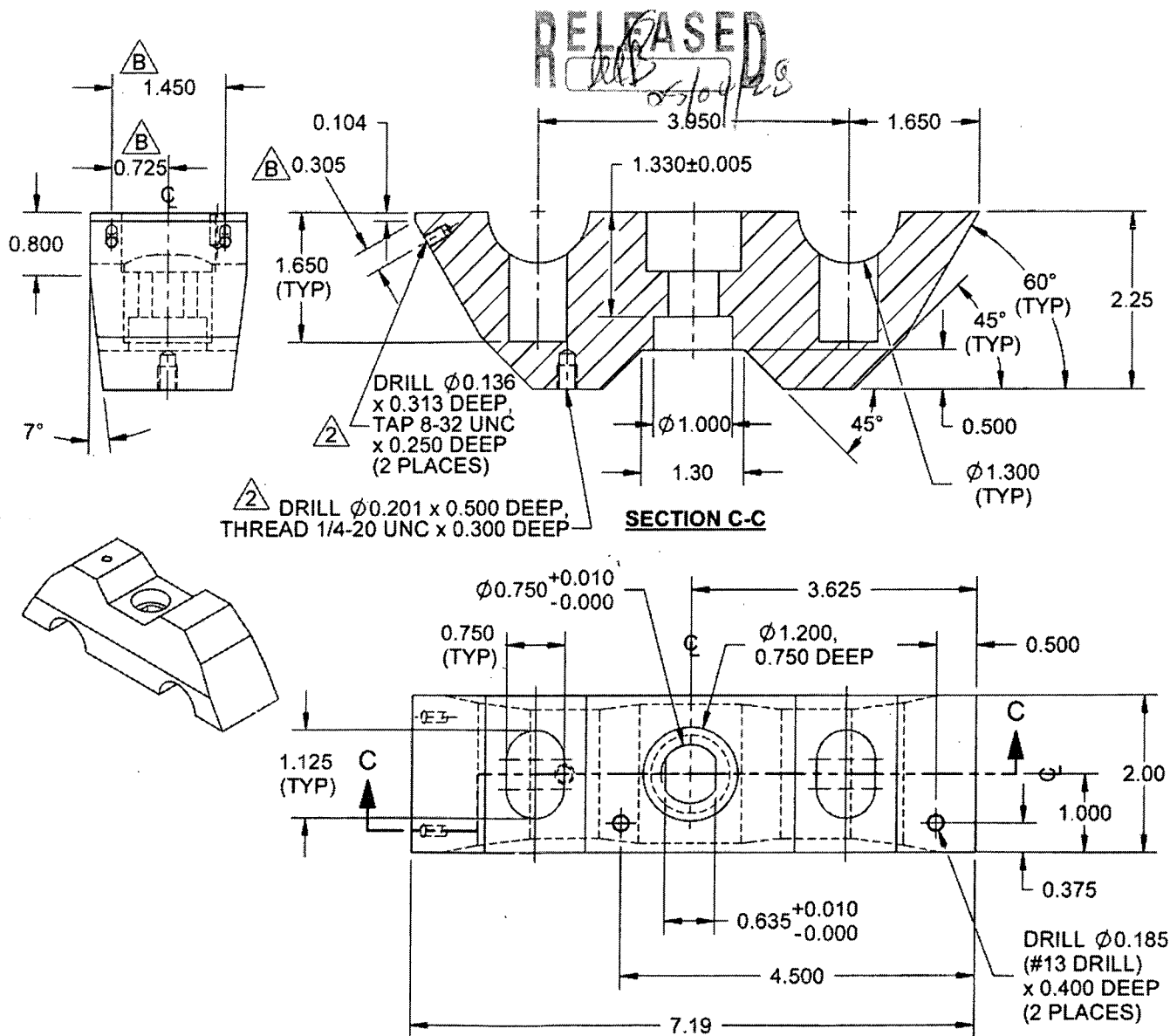
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
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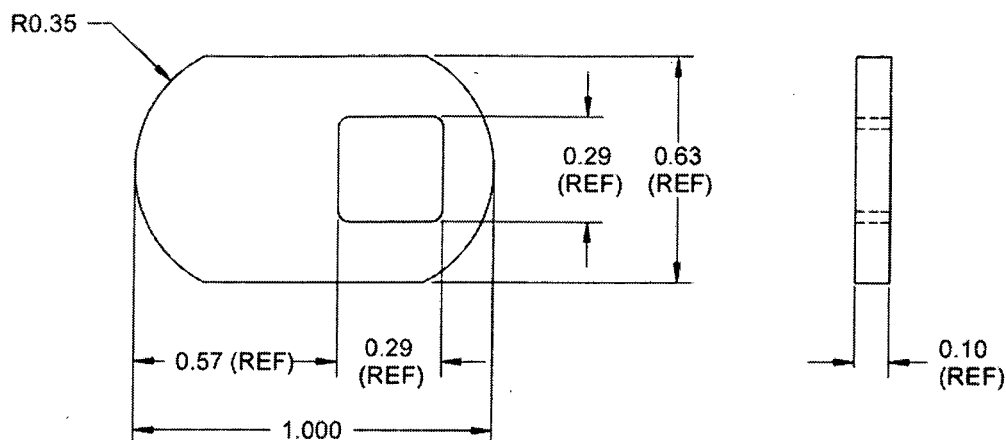
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 2:1

RELEASED
05/04/28

SPECIFICATION CONTROL DRAWING



w/o 58437

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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